

# Work Order ID 58531

May 10, 2010 12:36:28 PM



Page 1

Item ID: D2877

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 10/05/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2877	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

6061 .125

HB 10-5-18

(63)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-5-18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Swalson

Swalson  
(X63)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 10/05/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr if necessary

450/05/14 (63)

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

HL 10/05/14

63

Hand Finishing

Memo

0.00

150



QC

QC3- Inspect Part Finish

0.00

63 BL 10-5-19

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



Item Name: Saddle Spacer

Start Date: 10/05/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 28

0.00



Packaging

Memo

0.00

Packaging

10-5-20637 SL

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/20 HJu 10/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 58531



Parent Item: D2877



Parent Item Name: Saddle Spacer

Start Date: 10/05/2010

Required Date: 14/05/2010

Comments: IPP B ☐ 00.05.19 ☐ Added inspect level 8 ☐ EC  
IPP C ☐ 06.04.26 Water jet ☐ EC  
IPP Rev:D Now M6061-T6 06-06-23 JLM  
IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Start Qty: 40.00

Required Qty: 40.00

M6061T6S.125

Purchased

No

110

sf

188.1500

0.0607

3.8



1810-5-18

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT21

188.15

112476

19.2

113424

8.95

113608

96

114352

64

113424

63

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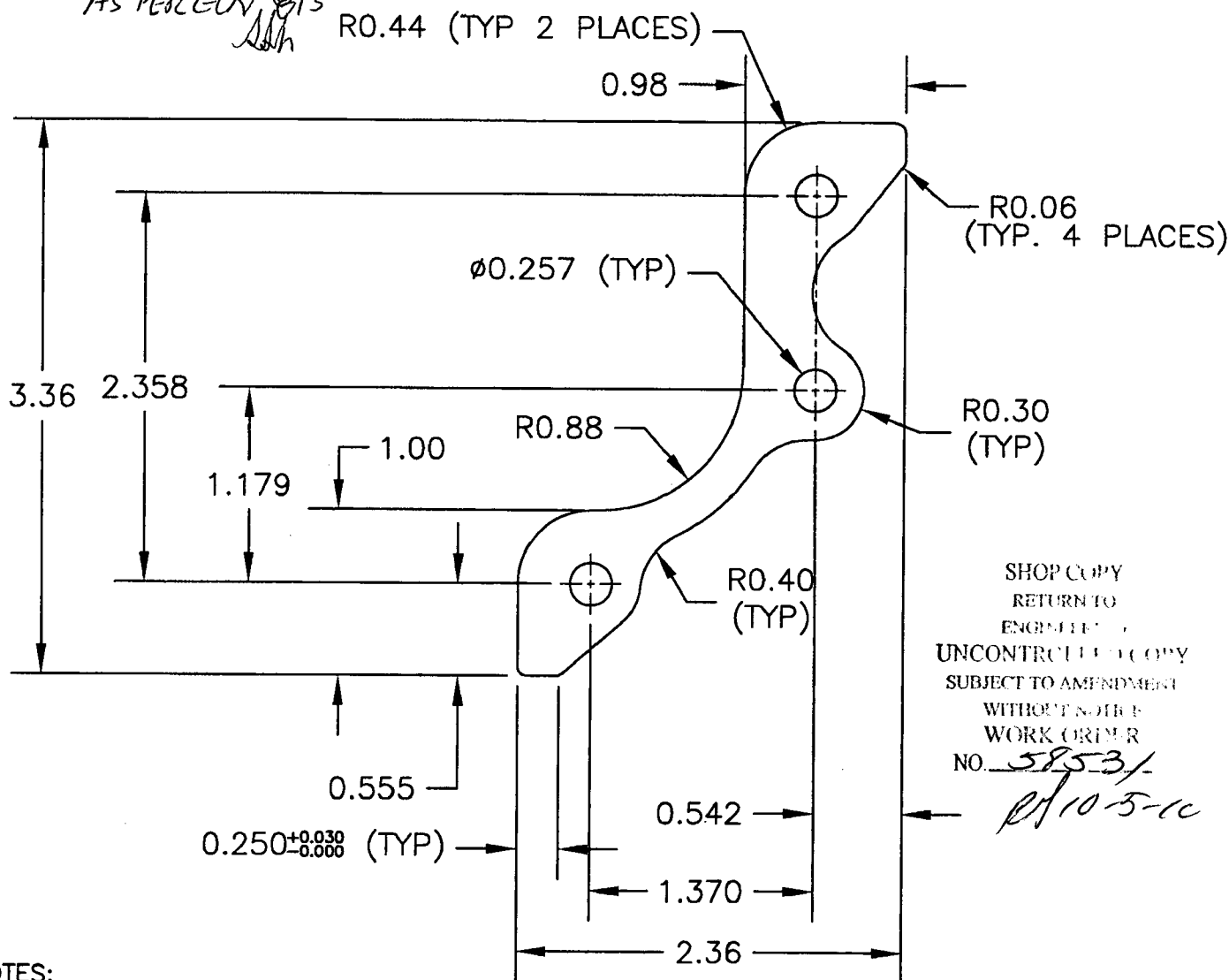
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED  
06.06.21

AS PER ECN 813  
*[Signature]*



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK  
(REF DART SPEC M6061T6S.125)  
OR  
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK  
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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